

What is claimed is:

1. The method of manufacturing a speed ring, steps
comprising:
 - 5 feeding an un-magnetized magnetic strip from a coil into a
magnetizing fixture;
stretching the magnetic strip to a predetermined length;
magnetizing the magnetic strip by sending an electric charge
through the strip;
 - 10 cutting the magnetized strip and retracting the coil;
advancing the magnetized strip to a trimming fixture having
a Hall Effect sensor;
detecting the center of a pair of poles with the Hall Effect
sensor;
 - 15 cutting the end of the magnetic strip;
detecting the number of pairs of poles in the magnetic
strip;
cutting the magnetized strip at the center of a pair of
poles, based on the number of pairs of poles to create
20 a second end; and
butting the first and second ends together.
2. The method of manufacturing the speed ring of claim 1
steps further comprising recording the length of the
25 stretched magnetic strip and assigning a part number to the
magnetic strip according to the stretched length.
3. The method of manufacturing the speed ring of claim 1
wherein the predetermined length is determined by a
30 microprocessor.

4. The method of manufacturing the speed ring of claim 1 wherein the magnetized strip is installed into a slot on a trolley that within the magnetized fixture.
- 5 5. The method of manufacturing the speed ring of claim 4 wherein the trolley is computer controlled.
6. The method of manufacturing the speed ring of claim 5 wherein the computer controlled trolley moves laterally to
10 pull the magnetic strip away from the coil, removing slack from the magnetic strip.
7. The method of manufacturing a speed ring described in claim 4 wherein the trolley is controlled by a computer that
15 determines and records the length of the stretched magnetic strip.
8. The method of manufacturing the speed ring of claim 1 wherein the magnetized strip is advance over the
20 Hall Effect sensor by a microprocessor-controlled servomotor.
9. The method of manufacturing the speed ring of claim 1 further comprising the step of installing the magnetic strip
25 in the inside of a ring with a fixed inside diameter, with the ends butted together.
10. The method of manufacturing the speed ring of claim 8 wherein the ring is a wheel.
- 30 11. The method of manufacturing a speed ring, steps comprising:

feeding an un-magnetized magnetic strip from a coil into the
 slot of a trolley of a magnetizing fixture;
 clamping the magnetic strip into place;
 stretching the magnetic strip to a predetermined length to
 5 create spacing between magnetic poles;
 magnetizing the magnetic strip by sending an electric charge
 through the strip;
 cutting the magnetized strip and retracting the coil;
 advancing the magnetized strip to a trimming fixture having
 10 a Hall Effect sensor;
 detecting the center of a pair of poles with the Hall Effect
 sensor;
 cutting the end of the magnetic strip;
 detecting the number of pairs of poles to determine the
 15 location of the final cut;
 cutting the magnetized strip at the center of a pair of
 poles to create a second end; and
 butting the first and second ends together.

20 12. The method of manufacturing a magnetic strip for a
 speed ring, steps comprising:
 advancing the magnetized strip to a trimming fixture having
 a microprocessor operably connected to a Hall Effect
 sensor;
 25 detecting the center of a pair of poles with the Hall Effect
 sensor;
 cutting the end of the magnetic strip;
 detecting the number of pairs of poles in the magnetic strip
 with the microprocessor; and
 30 cutting the magnetized strip at the center of a pair of
 poles, making the cut based on the number of pairs of
 poles detected by the microprocessor.